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CENTRAL INTELLIGENCE AGENCY
INFORMATION REPORT

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COUNTRY **Czechoslovakia**

SUBJECT **Test Results with Skoda Works 2.75 mm Jobber Twist Drills**

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1. [Redacted] tested a number of 2.75 mm jobber drills produced by the Skoda Works, Brno, Czechoslovakia. The drills were stamped 2.75-RB and trademark (Z).
2. The drills are hard ground cleared with very rough milling and hardening scale in the flutes. They were made of 18-4-1 tungsten high-speed steel, and were file hard. The micro structure revealed that the drills were badly overheated and burned, which indicates an excessively high or poorly controlled hardening heat. The drills were fairly well drawn.
3. Cutting tests were made in 1/4" plates that brinnelled 286-302 in SAE 1090 steel. A bushing was used, and the tests conducted at 2490 RPM and .002" feed. The drills gave reasonably good results insofar as holes per grind were concerned.
4. An attempt was made to use a 1/2" test block, but the drills would not drill at that depth. The failure to drill at 1/2" depth is attributed to the restricted flute space and the rough finish.

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